

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021516**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lui Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3007E-258. The welder is identified as 067877.

ZPMC Quality Control (QC) is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3007J-008. The welder is identified as 20009.

ZPMC Quality Control (QC) is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Segment 13AE / Bay 14

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3007AH-104. The welder is identified as 068097. Quality Control (QC) is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3007AH-106. The welder is identified as 068197. Quality Control (QC) is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of LD Base Metal Repair as per B-CWR # 2713. The welder is identified as 044779. Quality Control (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-FCM-Repair-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of Deck Panel DP3165 to DP3166 weld # SEG3019*-011. The welder is identified as 058100. Quality Control (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c_S-2. See attached photograph Pic_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3019AW-100. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3007E-228. The welder is identified as 055564. ZPMC Quality Control (QC) is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB. See attached photograph Pic_002.

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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
